

Date: Thursday, 8/30/2007 3:51:19 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 34365	
Estimate Number : 11966	
P.O. Number :	Part Number : D2055
This Issue : 8/30/2007 S.O. No. :	Drawing Number : D2055 C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : RMA	Drawing Revision : C1
Previous Run : 28823	Material :
Written By :	Due Date : 9/30/2007 Qty: 100 Um: Each
Checked & Approved By : <u>07.08.31</u>	
Comment : Est. C 02.03.07 Now turned in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R1000	ROUND BAR 1.00"
-----	--------------	-----------------



Comment: Qty.: 0.1094 f(s)/Unit Total : 10.9410 f(s)

ROUND BAR 1.00"

Material : 6061-T6 rod (QQA-A-225/8)

Batch: M104554

H.A

08/01/25 (100)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA203

Tumble & deburr all sharp edges as per dwg

H.A

08/01/25 (100)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A

08/01/25 (100)

QC8	SECOND CHECK
-----	--------------



Comment: SECOND CHECK

S.F 08/01/27

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

Drill hole as per dwg D2055

J.F.

08/01/27 (99)

6.0	QC8.2	INSPECT WORK TO CURRENT STEP
-----	-------	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

J.F.

08/01/27 (99)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/28	5	1 part is scrap, I drill the hole thru R.C. Hammer error	<u>08/01/28</u>	Scrap and Destroy no replace Qty (X1)	J-F. 08/01/28	<u>08/01/28</u>	<u>08/01/28</u>	<u>08/01/28</u>

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:51:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 34365

Part Number: D2055

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



counted/

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HP 08-01-28

X99

8.0

POWDER COATING

POWDER COATING



M100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

HP 08-01-31

(X99)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HP 08/02/01 (X99)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 74

AS 08/02/01

X99

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(99)

Comment: FINAL INSPECTION/W/O RELEASE

HP 08/02/06

Job Completion



mi 2008/2/04

(99)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

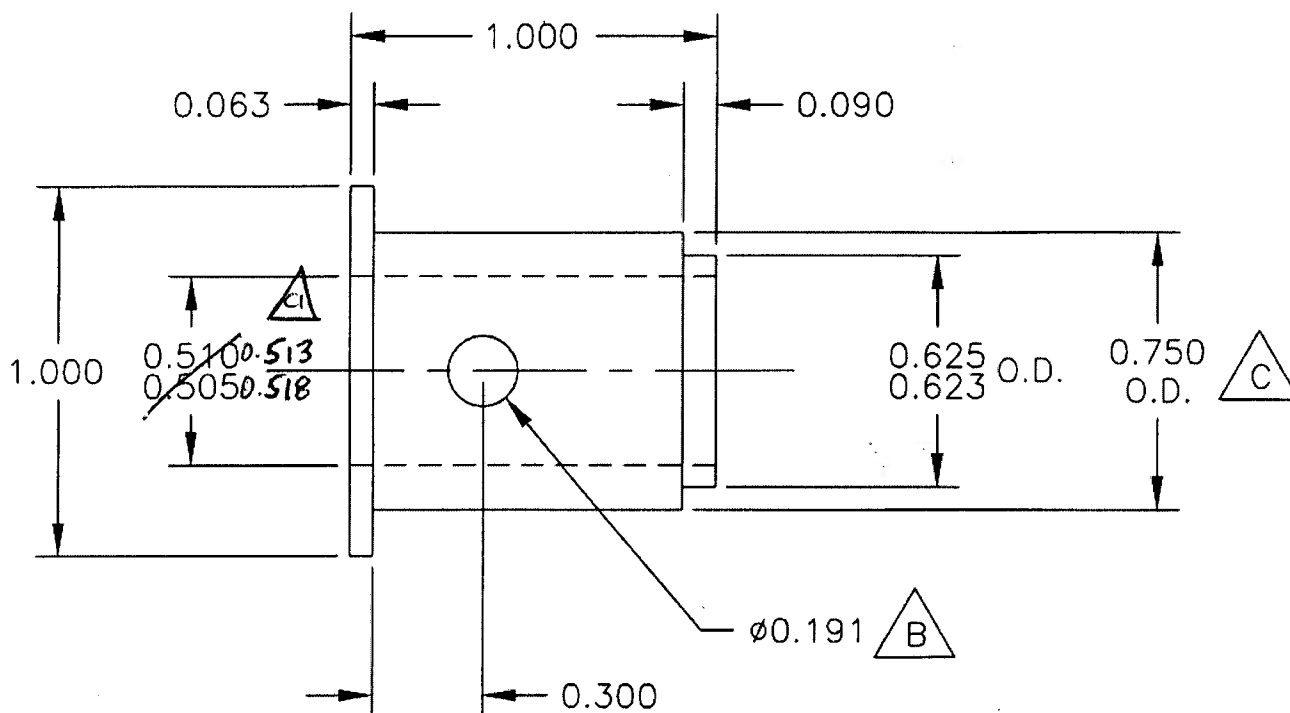
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	CP	DRAWING NO.	SHEET 1 OF 1
				D2055	
DATE	98.12.10	TITLE	CLAMP	SCALE	2:1
A	92.03.13	NEW ISSUE			
B	98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH			
C	98.12.10	ADDED 0.750 O.D. DIMENSION			
CI	CP	01.06.05	MODIFY HOLE SIZE, ADD P/LC OPTION		

RELEASED
48.12.10 KE



MATERIAL: 6061-T6 ROD (QQ-A-225/8)

FINISH: BLACK ANODIZE OR

BREAK ALL SHARP EDGES 0.015 MAX

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ACID ETCH & ALDINE PER
DART QSI 005 4.1
POWDER COAT BLACK SAMITEK (4.3.5.?)
PER DART QSI 005 4.3
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34365